

Date: Monday, 1/16/2006 4:19:54 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET ASSEMBLY
Job Number :	25534		
Estimate Number :	10759		
P.O. Number :	N/A	Part Number :	D34623
This Issue :	1/16/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3462 REV. <i>AB</i>
First Issue :	N/A	Project Number :	N/A
Previous Run :	24934	Drawing Revision :	<i>AB</i>
	Type :	Material :	N/A
	MACHINED PARTS	Due Date :	1/23/2006
Written By :	<i>SEE COMMENT BELOW</i>		Qty: 1 Um: Each
Checked & Approved By :	<i>SEE COMMENT BELOW</i>		
Comment :	EST REV. A 05.11.18 NEW ISSUE EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B0500X2500	304 BAR
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Comment: Qty.: 0.2500 f(s)/Unit Total: 0.2500 f(s)
 304 BAR .500 X 2.500 *batch: M18929*

EC 06.01.18

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blank " long

EC 06.01.18

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per Folio FA 603 and Dwg D3462
Make as per Dwg 03462
 2-Deburr

EC 06.01.18

4.0	QC5 QC5	INSPECT PARTS AS THEY COME OFF MACHINE
-----	--------------------	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

EC 06/01/18

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

EC 06/01/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 25534

Part Number: D34623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5415 06/01/19

①

06/01/19

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

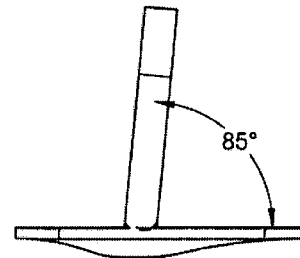
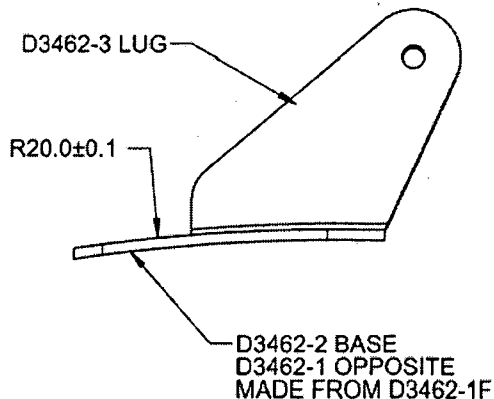
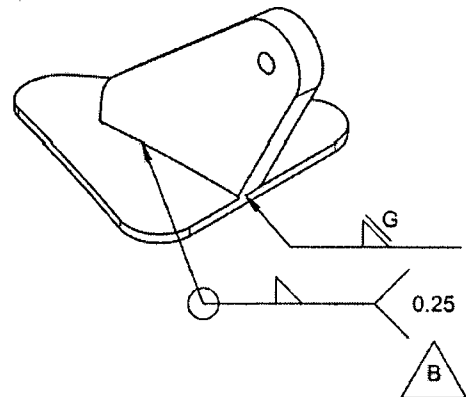
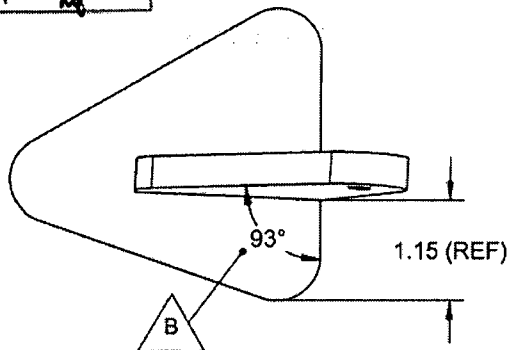
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3462	REV. B SHEET 1 OF 2
DATE 05.12.05	TITLE BRACKET ASSEMBLY		SCALE 1:2
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIMENSIONS	

RELEASED05.12.09 *[Signature]*

D3462-042 BRACKET ASSEMBLY (SHOWN)
D3462-041 OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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WORK ORDER
NO 25534

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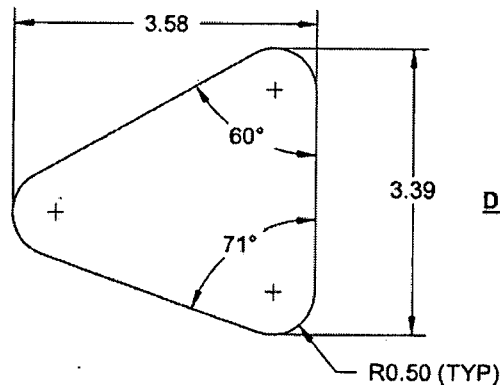
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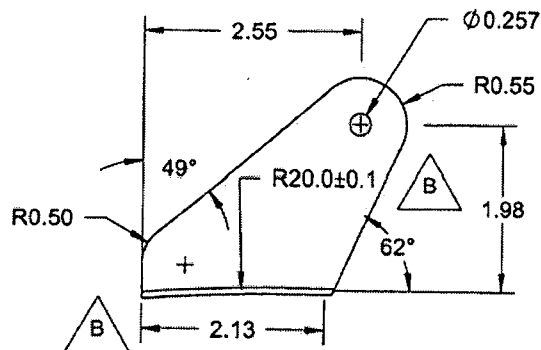
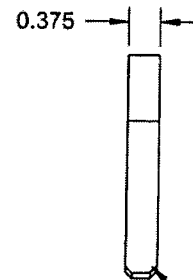
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3462	REV. B SHEET 2 OF 2
DATE 05.12.05		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED

05.12.09

**D3462-1F FLAT PATTERN****D3462-1F BASE**

- 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK (REF. DART SPEC. M304S11 GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

**D3462-3 LUG****D3462-3**

- 1) MATERIAL: AISI 304 SS BAR (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

0.08 x 45° CHAMFER
(TYP) RETURN TO
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WORK ORDER

NO. 25534

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